

Work Order ID 55730

January 29, 2010 8:24:39 AM

Page 1

Item ID: D3535-21

Accept

Revision ID:

Item Name: Wearshoe

Start Date: 1/28/10 Start Qty: 10.00

Required Date: 2/08/10 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-1-29

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

304 . 040

B 10-3-2

(B)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-3-2

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S10602/03

(12)

PD →

W/O: 55730		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/02/03	#120	Took Qty +1 For Acquisition template	8	10/02/03	x1	<i>[Signature]</i>	<i>[Signature]</i> 10/02/03

Part No: D 3535-21 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55730

January 29, 2010 8:24:39 AM



Page 2

Item ID: D3535-21

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 1/28/10 Start Qty: 10.00



Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

Form bend & joggle as per Dwg D3535 using DT8261 & DT8326

SB 10/02/09

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

=> S 10/02/09

(412)

150



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

Powder Coating

START TIME: 2:00pm FINISH TIME: 3:20pm

2/11/2580 10/02/0

(X12)

W/O:		WORK ORDER CHANGES					
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Work Order ID 55730

January 29, 2010 8:24:39 AM



Page 3

Item ID: D3535-21

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

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Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00

bk 10-02-10

(12)



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: *FP-17*

0.00

xl 10/02/10

(X12)

Ø



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/11

MF 10-2-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

January 29, 2010 8:24:43 AM

Page 1

Work Order ID: 55730



Parent Item: D3535-21

Parent Item Name: Wearshoe

Start Date: 1/28/10

Required Date: 2/08/10

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	256.1294	9.3947			



304/316 .040 Sheet



10-3-2

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	256.1294053	
110076	0.40253684	
112567	38.0765789	
112885	63.9578	
113062	145.1723	
113077	8.52018947	

112885

13

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 55730
Description: WEAR SHOE		Part Number: D3535-21
Inspection Dwg: D3535-21 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .188	+ .005 - .001	.192	X			
2.000	± .010	2.000	X			
2.000	± .010	2.000	>			
1.885	± .010	1.888	X			
300 X 300	± .010	304 X 306	X			
5.450	± .010	5.452	X			
10.900	± .010	10.899	X			
16.350	± .010	16.350	✓			
21.800	± .010	21.800	X			
27.250	± .010	27.250	>			
32.700	± .010	32.700	5			
6.00	± .030	6.00	X			
8.00	± .030	8.00	X			
16.00	± .030	16.00	X			
24.00	± .030	24.00	5			
.040	± .010	.040	X			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-3-2	Date: 10/2/03	Date:	N/A

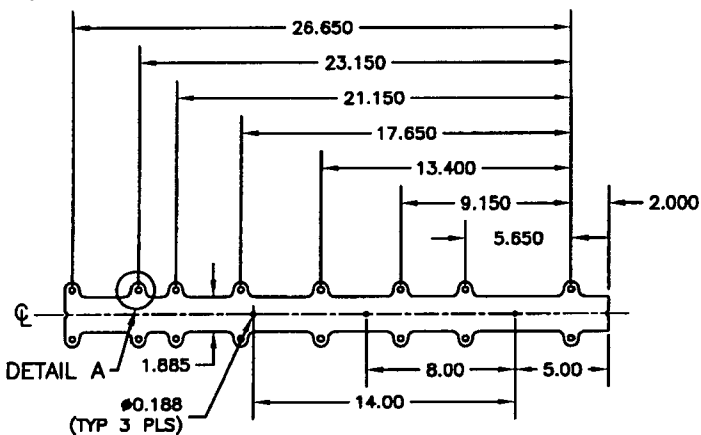
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART

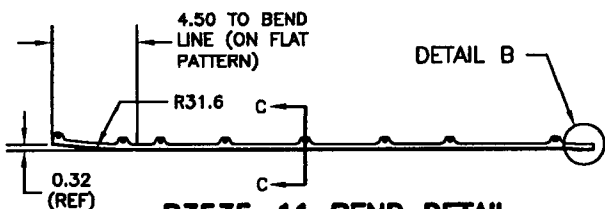
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07.04.24

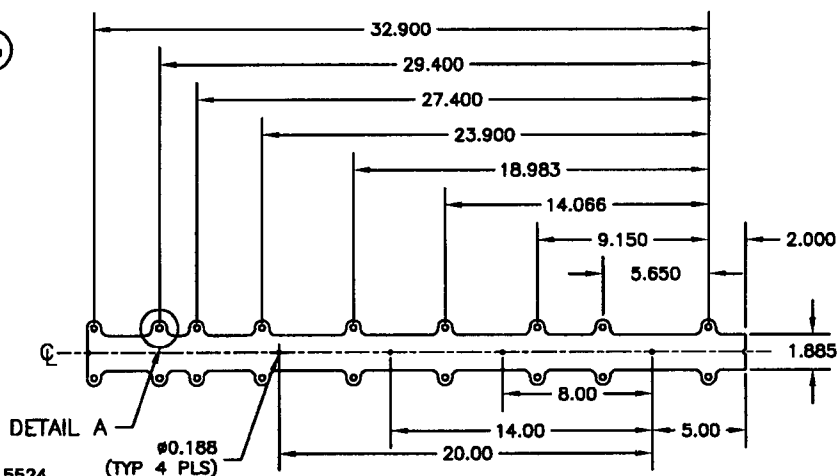
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 35230
P/HO-1-25



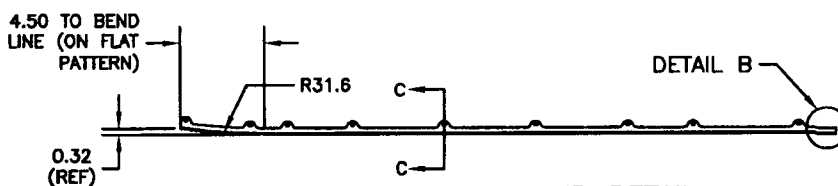
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D3535		
DATE		TITLE	SHEET 1 OF 7	SCALE
07.04.17		WEARSHOE		1:10
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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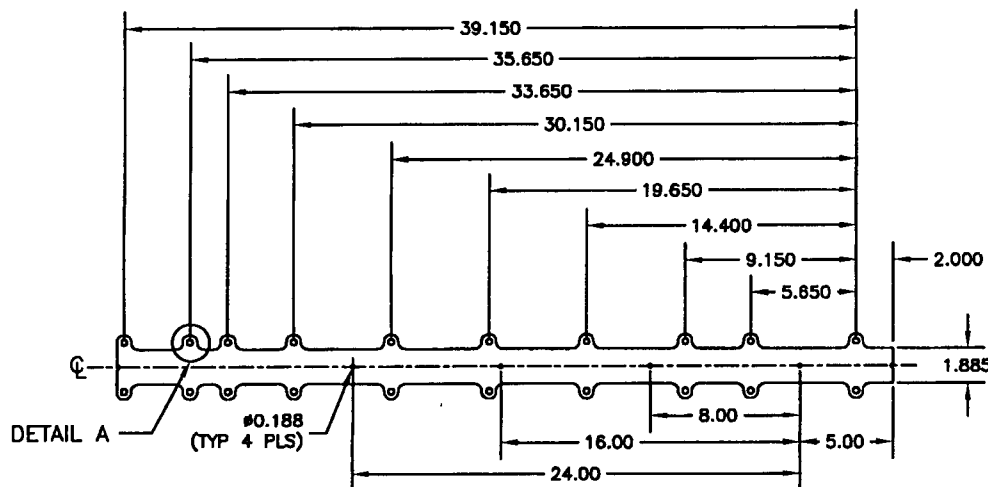
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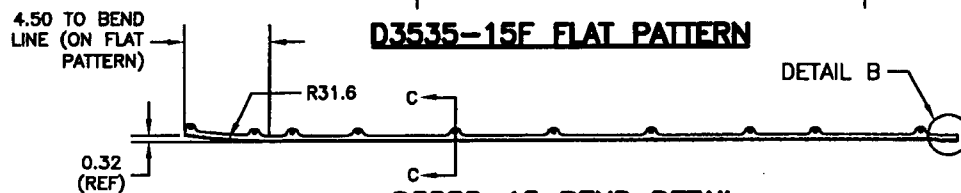
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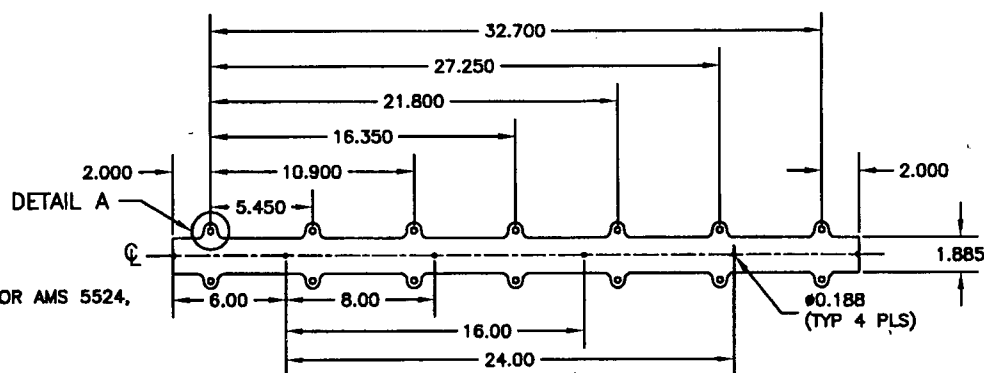
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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 2 OF 7
		SCALE
		1:10



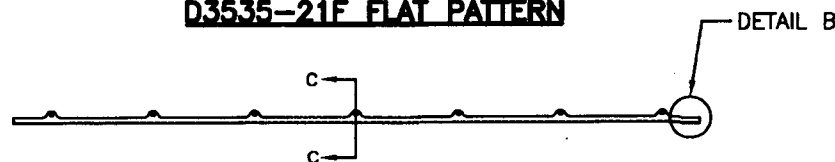
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

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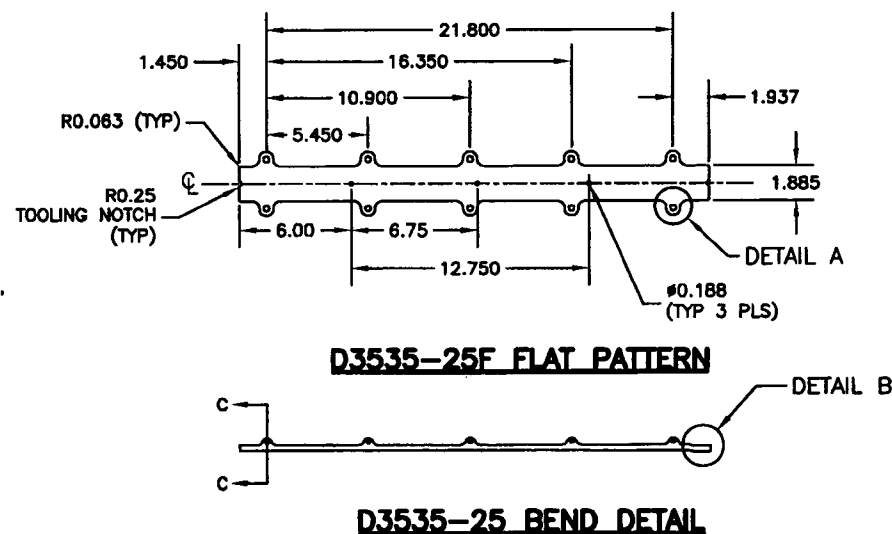
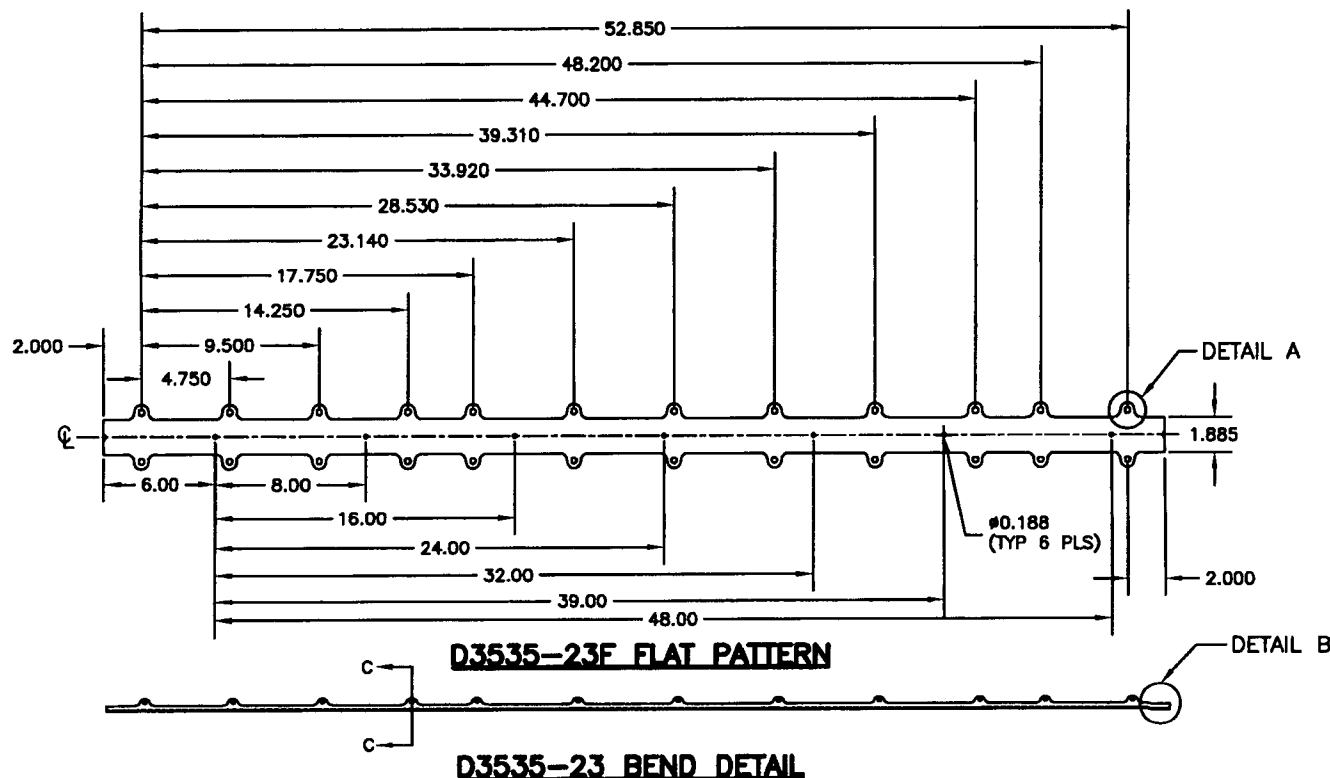
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DESIGN	CB	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
		SCALE	1:10	
		SHEET 3 OF 7		
		REV. B		

11/0 55230

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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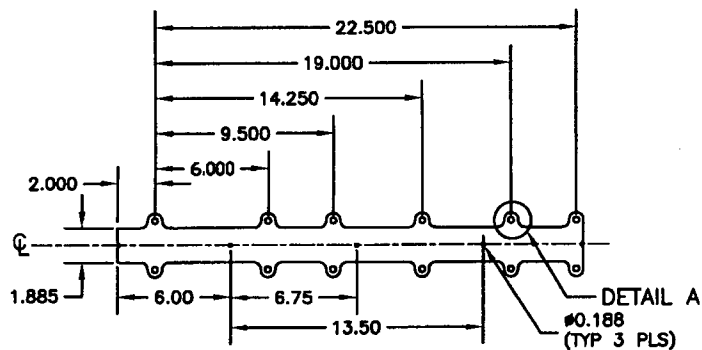
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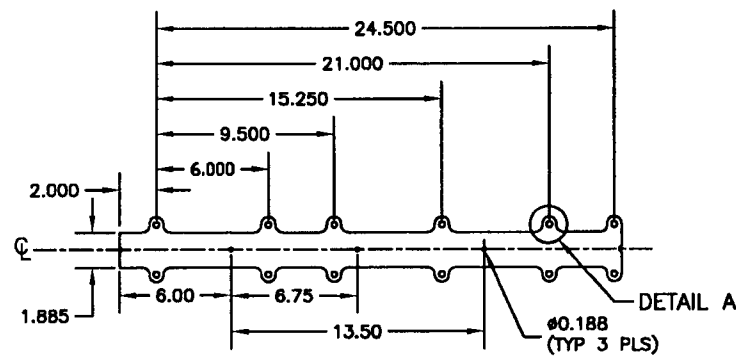
07.04.24



D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3535	SHEET 4 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:10

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

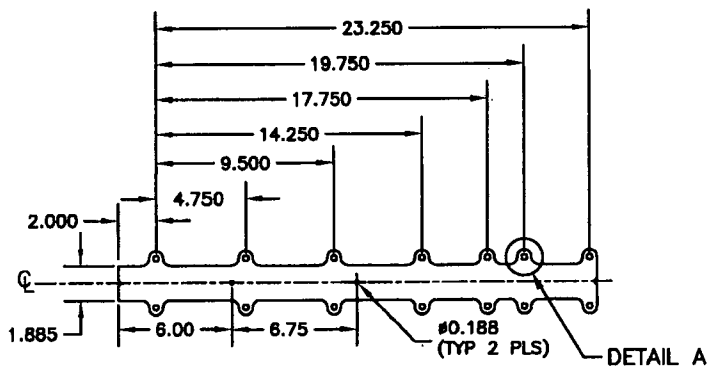
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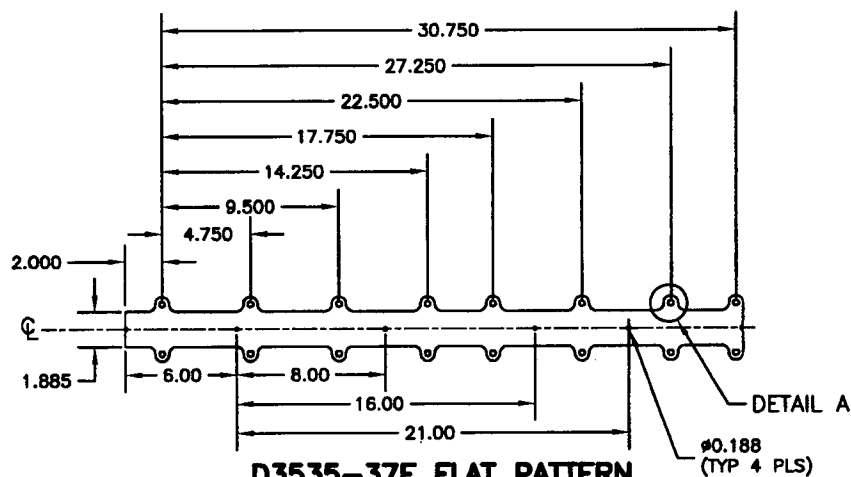
07.04.24



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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07.04.17	WEARSHOE	SHEET 5 OF 7
		SCALE 1:10

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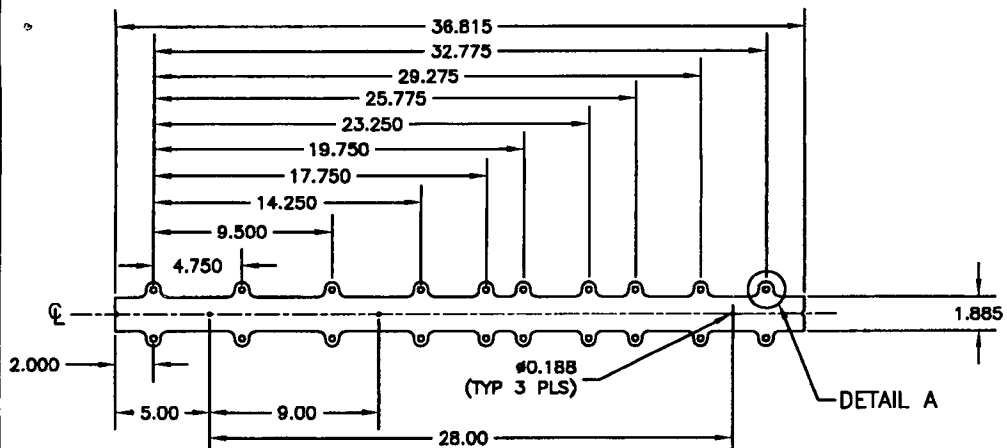
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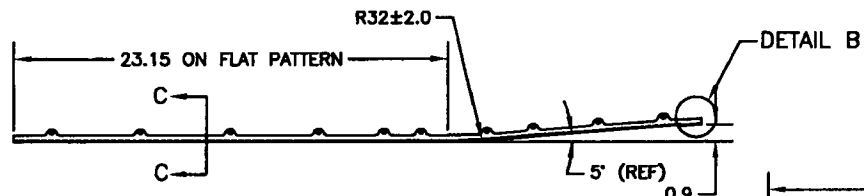
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		D3535	SHEET 6 OF 7
DATE	TITLE	WEARSHOE	SCALE
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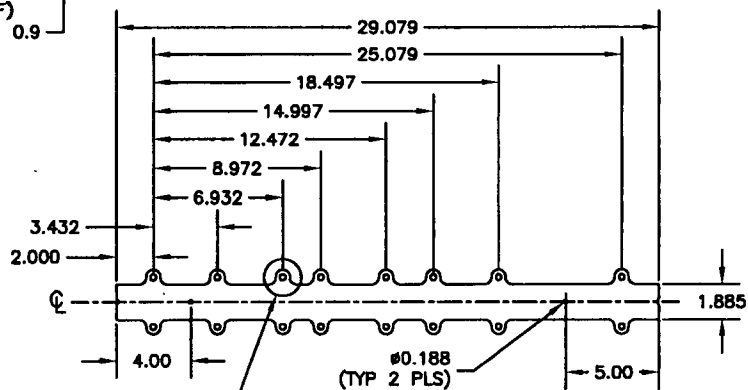
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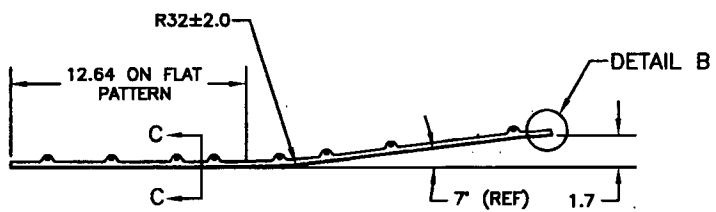
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

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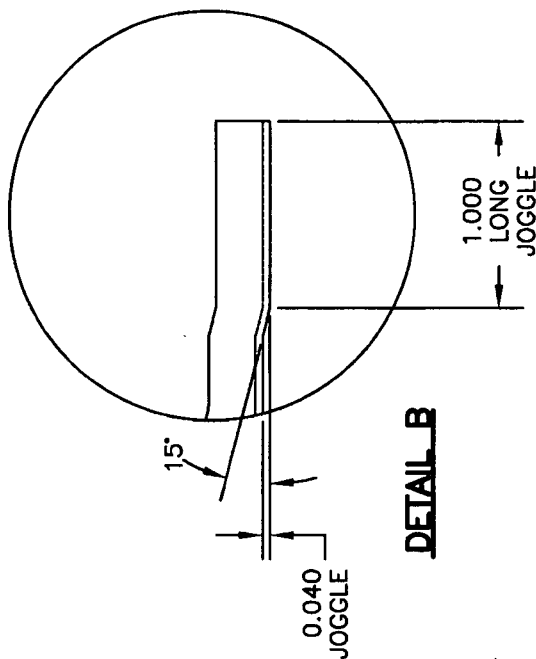
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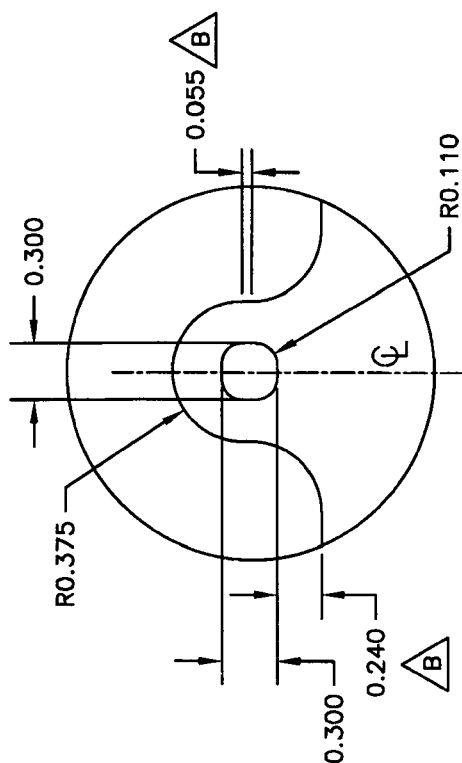


DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

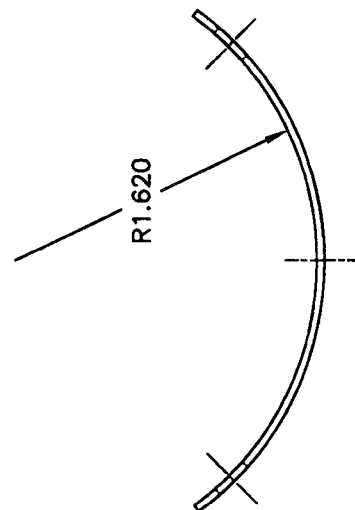
RELEASED
07.04.24



DETAIL B



DETAIL A



SECTION C-C

W/O:		WORK ORDER CHANGES					
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